

Work Order ID 94316

94316

Page 1

December-07-12 9:06:37 AM

Item ID: D350-607-041A

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Heli-Utility-Basket (Automatic Lid Opener)

Start Date: 12/07/12 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 12/11/12 Req'd Qty: 1.00 *1*

Customer:

Reference: Rework

Run Start

NR1

Approvals: Process Plan: U

Date: _____ Tooling: _____ Date: _____

Stop

NR2

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr								
D350-607-1	A								
DSI 9473									

100 0.00

100 DOCUMENT CONTROL

DC Memo 0.00

Document Control Photocopy bluefile & type labels per PPPD350-607-041A
CHG002

MLD 12-12-10

ST 12-12-07

110 0.00

110 Pick Kit

Packaging Memo 0.00

Packaging PULL FROM STOCK:
1 X D350-607-041 B 89629 CHG009

ST 12-12-07

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December-07-12 9:06:37 AM

Item ID: D350-607-041A

Accept

N900040100

Setup

Start

NS1

Revision ID:

Item Name: Heli-Utility-Basket (Automatic Lid Opener)

Stop

NS2

Start Date: 12/07/12 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 12/11/12 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

120

Small Fab

Small Fab

0.00

SD

12.12.07

Small Fab

Memo

0.00

Small Fab

REMOVE PROP ARM D2332-041
ADN RETURN TO STOCK B

84006

X

121

121

Large Fab

Large Fab

Memo

0.00

GRIND FLUSH D2327-3 BUSHINGS AT BOTH ENDS OF BASKET
TRIM STEEL MESH LOCALLY A/R
TRANSFER MARK AND DRILL 2 X 0.194 HOLES THRU BASKET LID &
BASE SQUARE TUBING PER
DETAIL L

X

122

122

HandFinish

Hand Finishing

Memo

TOUCH UP

0.00

→ QS 12/12/10

DAS		16		10		40	
DARIA AEROSPACE		N/A		1270 ABERDEEN ST		FAWKESE DRY, ON CANADA K0A 1K7	
PATENT		N/A		TEL 1-863-632-5200		WWW.DARIA.COM	
P/N		D350-607-041/-042		0-6	CHG009		
DESC.		Heli-Utility-Basket		STC	SH94-14		
LOT		B89629		STC	SR00213NY		
MODEL		AS350/355		STC			
IC APPROVAL #09-89							
MADE IN CANADA							
02/29/04							

1/4 Bl 12/12/10

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December-07-12 9:06:37 AM

Item ID: D350-607-041A

Accept

N900040100

Setup

Start *NS1*

Stop

NS2

Revision ID:

Item Name: Heli-Utility-Basket (Automatic Lid Opener)

Start Date: 12/07/12 Start Qty: 1.00

1

Cust Item ID:

Required Date: 12/11/12 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run

Start *NR1*

Stop

NR2

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

123

QC3- Inspect Part Finish

0.00

123

QC

Memo

0.00

Quality Control

1 4 4 81 12/12/12

124

124

Small Fab

Memo

0.00

0.00

1 4 60 12-12-10

Small Fab

RE-ASSEMBLE PER DRWG.

130

QC5- Inspect part completeness to step on W/O

0.00

130

QC

Memo

0.00

Quality Control

*****Ensure label for weight capacity is correct*****

DAS
16
8-10
12/12/10

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Item ID: D350-607-041A

Accept

N900040100

Setup

Start

NS1

Revision ID:

Item Name: Heli-Utility-Basket (Automatic Lid Opener)

Stop

NS2

Start Date: 12/07/12 Start Qty: 1.00

1

Cust Item ID:

Required Date: 12/11/12 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run

Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

170

QC21- Final Inspection - Work Order Release

0.00

12/12/2012

170

QC

Quality Control

Memo

0.00

12/20/12

Picklist Print

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Page 1

Work Order ID: 94316

Parent Item: D350-607-041A

Start Date: 12/07/12

Required Date: 12/11/12

Parent Item Name: Heli-Utility-Basket (Automatic Lid Opener)

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP RevA: New issue DD verified by:EC IPP RevB: as per dwg revC DD
10.01.18 verified by:EC IPP Rev:C as per ecn10-545 DD 10.04.19 verified by:EC IPP
Rev:D 10.10.18 remove D350-607-141 and added individual parts of D350-607-141 in DD
verf:JLM IPP REV:E 12.07.24 AS PER ECN 12-603 DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN310-4 NUT		Purchased	No			110	Each	75.0000	4	4	—		
				<u>Location</u>			<u>Loc Qty</u>						
				ST342			75						
				121349			2						
				122800			48						
				123900			25						
AN3C11A BOLT		Purchased	No			110	Each	38.0000	4	4	—		
				<u>Location</u>			<u>Loc Qty</u>						
				ST351			38						
				119798			8						
				122808			30						
D2332-041 Lid Prop Assembly 6.69" long		Manufactured	No				Each	17.0000					
				<u>Location</u>			<u>Loc Qty</u>						
				ST255	94006	.	17						
				89226			9						
				90057			2						
				90735			6						
D350-607-041 Heli-Utility-Basket, LH		Manufactured	No				Each	3.0000			1		
				<u>Location</u>			<u>Loc Qty</u>						
				BSKT			2						
				89093			1						
				89629			1						
				FG104			1						
				82160			1						

Picklist Print

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Work Order ID: 94316**Parent Item:** D350-607-041A**Start Date:** 12/07/12**Required Date:** 12/11/12**Parent Item Name:** Heli-Utility-Basket (Automatic Lid Opener)**Start Qty:** 1.00**Required Qty:** 1.00**D3953-1**

Gas Spring Bracket

Manufactured

No

110

Each

5.0000

2

2

*C*Location Loc Qty Loc Code

ST076 5

53760 5

D3953-11

Gas Spring Spacer

Manufactured

No

110

Each

9.0000

2

2

*53760**C*Location Loc Qty Loc Code

ST076 9

87089 9

D3953-13

Gas Spring Spacer

Manufactured

No

110

Each

14.0000

2

2

*87089**C*Location Loc Qty Loc Code

ST076 14

52761 2

89247 12

D3953-3

Gas Spring Stud, Lid

Manufactured

No

110

Each

41.0000

2

2

*52761**C*Location Loc Qty Loc Code

GA 1

87592 1

ST076 40

88494 26

89337 14

D3953-5

Gas Spring Stud, Base

Manufactured

No

110

Each

26.0000

2

2

*89337**C*Location Loc Qty Loc Code

ST076 26

85958 6

86593 20

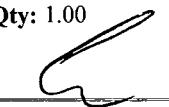
Picklist Print

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Work Order ID: 94316**Parent Item:** D350-607-041A**Parent Item Name:** Heli-Utility-Basket (Automatic Lid Opener)**Start Date:** 12/07/12**Required Date:** 12/11/12**D3953-7**
Spring Spacer

Manufactured No 110 Each 45.0000

2 2 

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST076	45	
87444	9	87444
88393	24	
89248	12	

D3953-9
Gas Spring Washer

Manufactured No 110 Each 39.0000

4 4 

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST076	39	
88462	9	88462
89307	30	

D3969-1
Spring (Basket Lid)

Manufactured No 110 Each 9.0000

2 2 

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST262	9	
73523	1	
84424	8	

MS21043-3
Nut

Purchased No 110 Each 860.0000

8 8 

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FG	72	
103691	72	
FP001	64	
123525	64	
ST315	724	
118077	2	
118614	7	
118686	30	
119758	20	
121255	20	
122993	145	
123899	500	123 899

Picklist Print

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Work Order ID: 94316**Parent Item:** D350-607-041A**Start Date:** 12/07/12**Required Date:** 12/11/12**Parent Item Name:** Heli-Utility-Basket (Automatic Lid Opener)**Start Qty:** 1.00**Required Qty:** 1.00**MS24665-2-12**

Purchased

No

110

Each

94.0000

4

4

COTTER PIN

*LR***NAS1149C0332R**

Washer

Purchased

No

LocationLoc QtyLoc Code

ST299

94

118078

94

118078

8

8

*LR***NAS1149C0432R**

Washer

Purchased

No

LocationLoc QtyLoc Code

FP001

15

123355

15

ST292

9399

123248

65

123759

9334

123759

4

4

*C 12/12/10 ①*LocationLoc QtyLoc Code

GA

106

121255

106

ST292

3520

117291

40

119124

480

122441

3000

*119124**AN3 C 16A.**122814**H.**(4)**BL 12-12-10.*

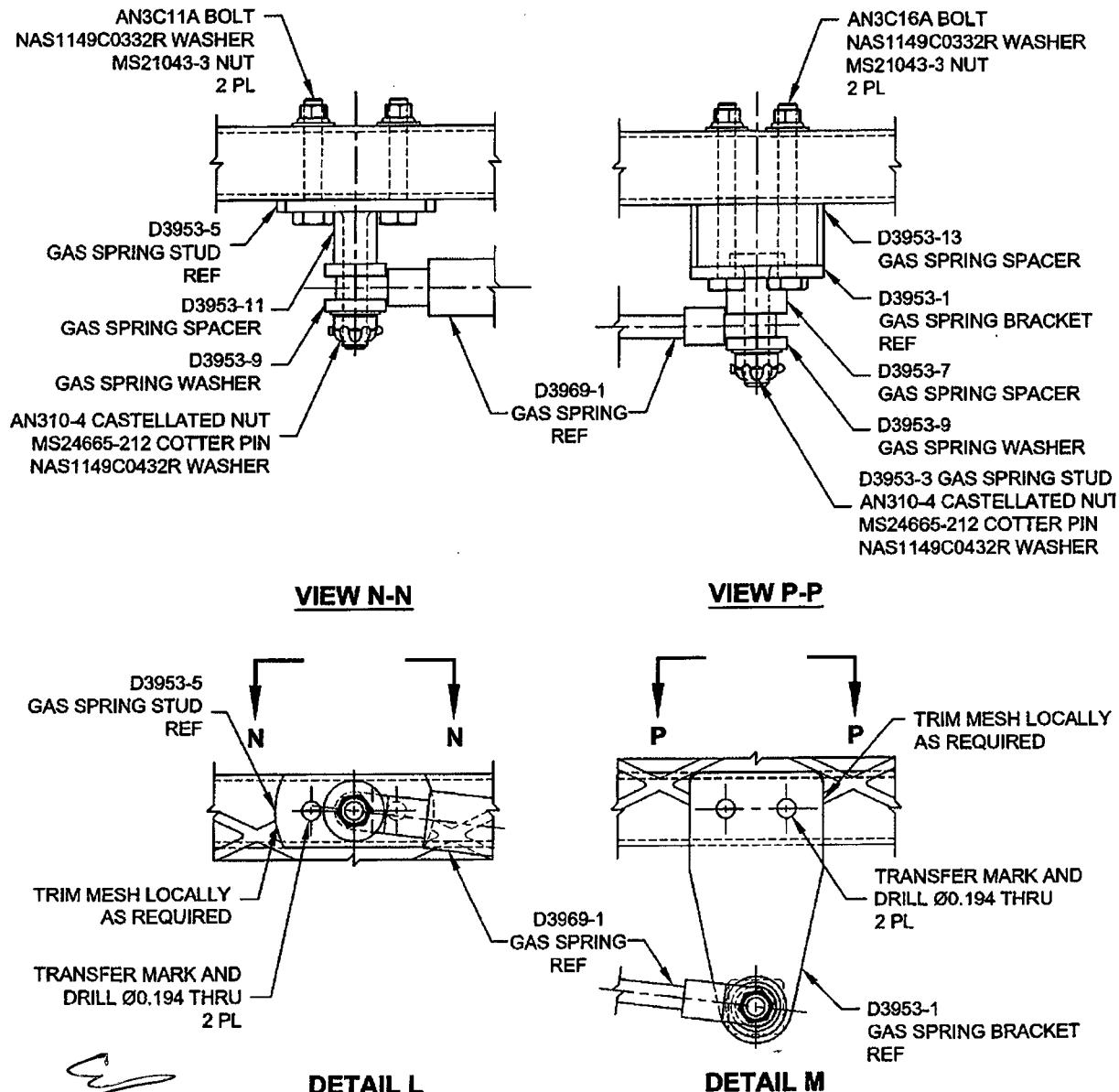


Figure 8b – Automatic Lid Opener Installation

2.0 GENERAL NOTES

COMPATIBILITY

Compatibility of this installation with the aircraft is the responsibility of the installer. Ensure that this installation does not conflict with a previous modification.

CONTINUING AIRWORTHINESS

This installation should be maintained in accordance with the Instructions for Continued Airworthiness ICA-D350-607.

3.0 INSTALLATION PROCEDURE

For installation of D350-607-041/-041A/-043/-043A/-045/-045A/-047/-047A *Heli-Utility-Basket™*.

- 3.1 **NOTE:** For aircraft equipped with high gear, the Dart *Heli-Utility-Basket™* is compatible with Dart D350-591 high-gear steps. The D350-591 step height must be set as shown in Figure 1 to ensure that the cargo doors will open with the basket installed. For aircraft equipped with low gear, the Dart *Heli-Utility-Basket™* is not compatible with Dart D350-591 low gear steps; any Dart low gear step will have to be removed before basket installation.
- 3.2 The D350-607-041/-043/-045/-047 *Heli-Utility-Basket™* may be installed on either the LH or RH side of the aircraft. For RH installations, the D2332-041 Prop Assembly should be moved to the aft end of the basket. Use existing hardware and ensure nuts face aft.
- 3.3 Install the D2732-030 Rubber Cushions, D2230-1 Lugs and D2324 Strut onto the basket as shown in Figures 2 and 3, using the AN4 hardware shown.
NOTE: The AN4-15A bolts may be replaced with a stainless steel positive locking quick release pin with a minimum double shear strength of 2400 lbs and with a 1.0 inch grip length and 0.25 inch diameter (Avibank: BLC4B10S, BLC4TA10S, BLC4R10S, BLC4LA10S; MS Number: MS17984C410, MS17985C410, MS17986C410, MS17987C410)
- 3.4 Present the basket to the crosstubes. Propping the basket at the appropriate height can facilitate installation. If the basket is being installed on high gear with Dart D350-591 steps, temporarily place a 0.063" (1.6mm) shim on the step and rest the basket on the shim. Remove shims after bolts are torqued.
- 3.5 Attach the basket with the D2230-3 Clamps and AN4 hardware shown in Figure 2 and 3. Leave bolts loose to allow for adjustment.
- 3.6 Tighten clamp bolts once height is positioned properly. Do not exceed torque of 60 in-lb (6.8 Nm) on the nuts. **CAUTION:** Over-torquing the nuts could lead to structural damage of the clamps.

4.0 INSTALLATION OF OPTIONAL KITS

4.1 D350-607-141 AUTOMATIC LID OPENER INSTL (FOR USE ON -041 BASKET)

NOTE: Once this modification is complete you will not be able to re-install the D2332-041 Prop Arm.

- 4.1.1 Remove the D2332-041 Prop Arm.
- 4.1.2 Grind Flush the D2327-3 Spacer Bushing on both ends of the Basket as shown in Figure 8a (it is permissible to grind all 4 Spacers Flush). Touch up paint Per ICA-D350-607 Section 5.1 Item 4.
- 4.1.3 Locate the D3953-1 Gas Spring Bracket as shown in Figure 8a. Trim Steel Mesh locally as required. Touch up paint per ICA-D350-607 Section 5.1 Item 4. Transfer mark and drill 2X Ø0.194 holes thru the Basket lid square tube structure as shown in Detail M. Install the D3953-1 Gas Spring Bracket & D3953-13 Gas Spring Spacer using 2X AN3C16A Bolt, 2X NAS1149C0332R Washer & 2X MS21043-3 NUT as Shown in View P-P.

- 4.1.4. Locate the D3953-5 Gas Spring Stud as shown in Figure 8a. Trim Steel Mesh locally as required. Touch up paint per ICA-D350-607 Section 5.1 Item 4. Transfer Mark and Drill 2X Ø0.194 holes thru the Basket base square tube structure as shown in Detail L. Fasten D3953-5 IAW View N-N using 2X AN3C11A Bolt, 2X NAS1149C0332R Washer & 2X MS21043-3 Nut.
- 4.1.5. Install 1X D3953-11 Gas Spring Spacer onto the D3953-5 Stud as shown in View N-N. Install the large end of the D3969-1 Gas Spring onto the D3953-5 Gas Spring Stud and Fasten in Place using 1X D3953-9 Gas Spring Washer, 1X NAS1149C0432R Washer, 1X AN310-4 Castellated Nut & 1X MS24665-212 Cotter Pin as shown in View N-N. Install Cotter Pin per MS33540 or AC43.13 chapter 7-127.
- 4.1.6. Insert the D3953-3 Gas Spring Stud into the D3953-1 Gas Spring Bracket & Insert the D3953-7 Gas Spring Spacer onto the D3953-3 Gas Spring as Shown in View P-P. Raise the Basket lid and install the rod end of the D3969-1 Gas Spring onto the D3953-3 Gas Spring Stud using 1X D3953-9 Gas Spring Washer, 1X NAS1149C0432R Washer, 1X AN310-4 Castellated Nut & 1X MS24665-212 Cotter Pin as shown in View P-P. Install Cotter Pin Per MS33540 or AC43.13 Chapter 7-127.
NOTE: The D3953-3 Gas Spring Stud can be held in place with a 9/16 open end spanner/wrench.
NOTE: With the lid in the closed position the Gas Spring should not be fully compressed.
- 4.1.7. Repeat steps 4.1.2 through 4.1.6 at the other end of the Basket.
- 4.1.8. Test the installation. If installed properly the Gas Springs should assist the Basket user in both opening and closing the basket lid.

4.2 D350-607-143 AUTOMATIC LID OPENER INSTL (FOR USE ON -043/-047 BASKET)

NOTE: This kit may be installed at either end of the Basket. However, the Prop Arm must be removed in either case as it will interfere with the function of the Gas Spring.

- 4.2.1 Remove the D2332-041 Prop Arm.
- 4.2.2 Grind flush the D2327-3 Spacer Bushing on the end of the Basket where the lid opener is to be installed as shown in Figure 9a (it is permissible to grind all 4 spacers flush). Touch up paint per ICA-D350-607 Section 5.1 Item 4.
- 4.2.3 Locate the D3953-15 Gas Spring Bracket as shown in Figure 9a. Trim steel mesh locally as required. Touch up paint per ICA-D350-607 Section 5.1 Item 4. Transfer mark and drill 2X Ø0.194 holes thru the Basket Lid Square tube structure as shown in Detail R. Install the D3953-15 Gas Spring Bracket & D3953-17 Gas Spring Spacer using 2X AN3C15A BOLT, 2X NAS1149C0332R Washer & 2X MS21043-3 Nut as shown in View T-T.
- 4.2.4 Locate the D3953-5 Gas Spring Stud as shown in Figure 9a. Trim Steel Mesh Locally as required. Touch up paint per ICA-D350-607 Sections 5.1 Item 4. Transfer mark and drill 2X Ø 0.194 holes thru the Basket Base square tube structure as shown in Detail S. Install 2X AN3C11A Bolt, 2X NAS1149C0332R Washer & 2X MS21043-3 Nut as shown in View U-U. Install the rod end of the D3969-1 Gas Spring onto the D3953-5 Gas Spring Stud using 1X D3953-9 Gas Spring washer 1X NAS1149C0432R Washer, 1X AN310-4 Castellated Nut & 1X MS24665-212 Cotter Pin as shown in View U-U. Install Cotter Pin per MS33540 or AC43.13 Chapter 7-127.
- 4.2.5 Insert the D3953-3 Gas Spring Stud into the D3953-15 Gas Spring Bracket & insert the D3953-7 Gas Spring Spacer onto the D3953-3 Gas Spring Stud as shown in View T-T. Raise the Basket lid and install the D3969-1 Gas Spring onto the D3953-3 Gas Spring Stud and fasten in place using 1X D3953-9 Gas Spring Washer 1X NAS1149C0432R Washer, 1X AN310-4 Castellated Nut & 1X MS24665-212 Cotter Pin as shown in View T-T. Install Cotter Pin per MS33540 OR AC43.13 Chapter 7-127.
NOTE: The D3953-3 Gas Spring Stud can be held in place with a 9/16 open end spanner/wrench.
NOTE: With the lid in the closed position the Gas Spring should not be fully compressed.